

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017380**Date Inspected:** 03-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

FCAW welding of repair weld is identified as 1G-008 of BK006A1-002 for BK006A-002. The welder is identified as 062732. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-1G(1F)-Repair and B-WR15538.

FCAW welding of repair weld is identified as 1G-008 of BK004A1-005 for BK004A-005. The welder is identified as 062762. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-1G(1F)-Repair and B-WR15540.

FCAW welding of weld is identified as 3G-065 of BK004A6-009 for BK004A-009. The welder is identified as 062734. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2333-Tc-P4-F.

FCAW welding of weld is identified as 4G-098 of BK004A8-009 for BK004A-009. The welder is identified as 208632. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2334-Tc-P4-F.

FCAW welding of weld is identified as 4G-088 of BK004A6-007 for BK004A-007. The welder is identified as

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62904. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2334-Tc-P4-F.

FCAW welding of weld is identified as 1G-008 of BK004A1-001 for BK004A-001. The welder is identified as 062752. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-B-U2-F.

During in process it is found that ZPMC QC MT personnel performing MT on Plug welds of bike path is identified as BK004A-004, the weld is identified as BK004A2-004-014,015,017,019,020.

They got lot of cracks in plug welds. Without informing Engineer and make report they carried out repair in BK004A2-004-014. This is informed to ZPMC QC Mr. Guo xing hui. He agreed to Make CWR and stop welding. Repair rate is approximately 30%.

This QA inspector performed MT 15% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG Bike path. The weld designations reviewed as follows.

BK004A1-002-018(Side-B)

BK004A1-012-018(Side-B)

BK004A1-002-016(Side-B) – WD needs ground flush of the weld, but ZPMC not yet done, cancelled.

BK004A1-012-016(Side-B) → WD needs ground flush of the weld, but ZPMC not yet done, cancelled.

This QA inspector performed (Re-MT) MT 15% of Heat straightened weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG Bike path. The weld designations reviewed as follows.

BK004A-012

BK004A3-012-025

BK004A4-012-014,015,067

BK004A6-012-150,151,155,036

BK004A8-012-121,125,024,036

BK004A-002

BK004A3-002-026

BK004A4-002-015,066

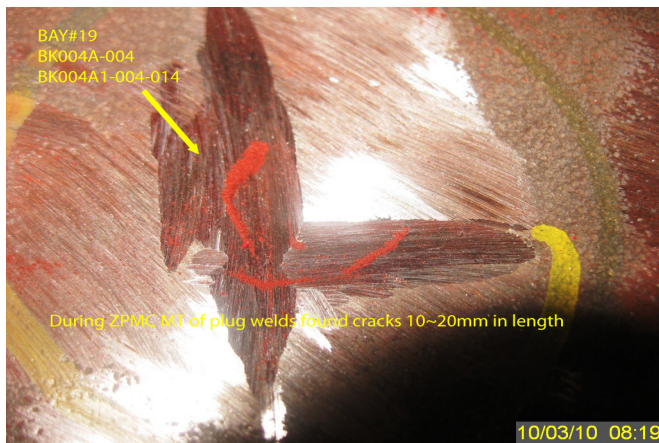
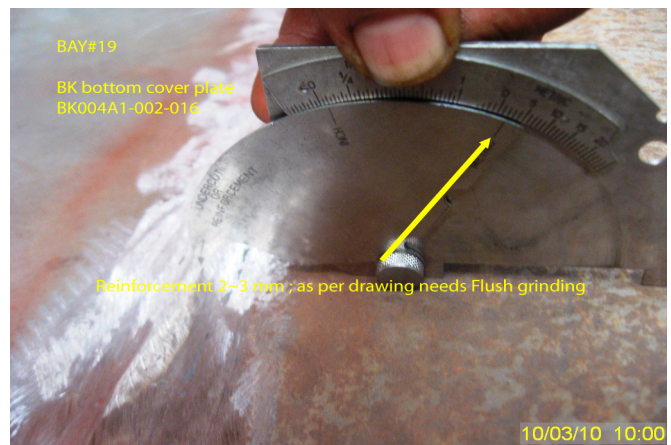
BK004A6-002-151,154,155,024

BK004A8-002-121,125,126,024.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By: Kumar,Chadra

Quality Assurance Inspector

Reviewed By: McClendon,Timothy

QA Reviewer